

CLAIMS

1. A sheet-like wiper of a nonwoven fabric formed by entangling fibers with each other by a high-pressure water jet stream, wherein an amount of micro-matter of  
5 100 $\mu$ m long or more falling-off therefrom is 20,000 pieces/m<sup>2</sup> or less, an amount of material dissolved therefrom into acetone is 340 mg/kg or less, and the water absorption is 8 ml/g or more.

2. A wiper as defined by claim 1, wherein the  
10 amount of micro-matter of 100  $\mu$ m long or more falling-off therefrom is 14,000 pieces/m<sup>2</sup> or less, the amount of material dissolved therefrom into acetone is 190 mg/kg or less, and the water absorption is 9 ml/g or more.

3. A wiper as defined by claim 1 or 2, wherein the  
15 nonwoven fabric contains cellulose filament fiber of 40% by weight or more, and the cellulose filament fiber is cupra ammonium rayon.

4. A wiper as defined by claim 3, wherein the  
20 content of the cellulose filament fiber is 85% by weight or more.

5. A method for manufacturing a wiper, comprising a process for producing nonwoven fabric of cellulose filament fiber by a wet type cellulose spun-bonding method wherein cupra-ammonium cellulose solution is  
25 continuously coagulated, regenerated, rinsed, entangled, dried and taken up to form a nonwoven fabric, a process for combining the nonwoven fabric with other nonwoven fabric if necessary, a process for cutting the nonwoven fabric to be a flat sheet-like wiper, a process for  
30 wetting the wiper with liquid if necessary and/or a process for sterilizing the wiper if necessary, wherein the entanglement process is carried out by placing a buffer plate having an opening degree in a range from 10 to 47% on a non-entangled web and applying onto the  
35 buffer plate a water jet stream having a total impact energy value (F) in a range from  $0.5 \times 10^9$  to  $3.0 \times 10^9$

joule·newton/kg to entangle fibers in the web.